




Work Order ID 61724

Tuesday, August 31, 2010 2:41:31 PM




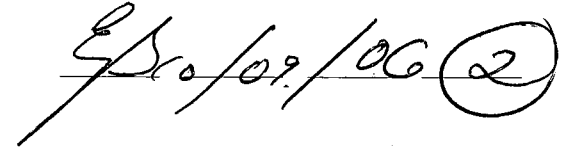
Page 1


Item ID: D2803-041 Accept  Setup Start 
Revision ID: 
Item Name: Bracket Assembly Stop 
Start Date: 8/31/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 9/7/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan:  Date: 10-8-31 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2803	Rev B								


100
 Small Fab 0.00
Small Fab Memo 0.00
Small Fab Press D2805-1 into arm as per Dwg D2803

 8/30/09/06 (2)

110
 QC 0.00
Quality Control Memo 0.00

8.062107

(42)
-041

120
 Powdercoat 0.00
Powder Coating Memo 0.00

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
M 114841

BR 10-9-9

(2)

START TIME: 12:00 ☐ OVEN TEMPERATURE:
320° ☐ FINISH TIME: 12:30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61724

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Page 2

Item ID: D2803-041

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 8/31/2010 Start Qty: 2.00

Required Date: 9/7/2010 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

140	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--



Small Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Small Fab	Press D2809 into arm as per Dwg D2803								
-----------	---------------------------------------	--	--	--	--	--	--	--	--

150	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--



Small Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Small Fab	Assemble as per Dwg D2803.								
-----------	----------------------------	--	--	--	--	--	--	--	--

E 5/10/09/13 (2)

E 5/10/09/13 (2)

E 5/10/09/13 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




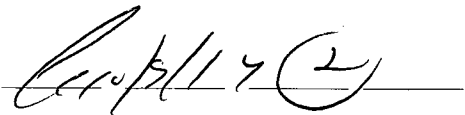

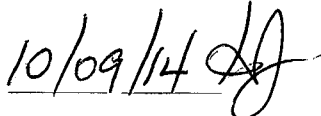
Work Order ID 61724

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Page 3

Item ID: D2803-041 Accept  Setup Start 
Revision ID:
Item Name: Bracket Assembly Stop 
Start Date: 8/31/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 9/7/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		810602113					
170  Packaging Packaging	Identify as per dwg & Stock Location: 147 Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 MF 10-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 61724

Parent Item: D2803-041

Parent Item Name: Bracket Assembly



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F005.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-1 Bracket		Manufactured	No			100	Each	4.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST148				4					
					46610			2					
					56186			2					
D2805-1 Stop		Manufactured	No			100	Each	12.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST024				12					
					46735			2					
					58527			10					
NAS1515H3 Washer		Purchased	No			100	Each	90.0000	4	8			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST277				90					
					111268			90					
AN3C16A Bolt		Purchased	No			150	Each	75.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST352				75					
					111193			25					
					111425			50					

EP 8/30/09/06

EP 8/30/09/06

EP 8/30/09/06

EP 8/30/09/06

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 61724

Parent Item: D2803-041

Parent Item Name: Bracket Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 2.00

Required Qty: 2.00

D2809

Manufactured No

150 Each

51.0000

1

2



Bushing



ES 10/09/06

Location

Loc Qty

Loc Code

ST025

51

34035

12

46438

1

47733

38

2

MS21043-3

Purchased No

150 Each

2,733.000

2

4



Nut



ES 10/09/06

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2657

109147

49

111383

46

112314

2562

4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

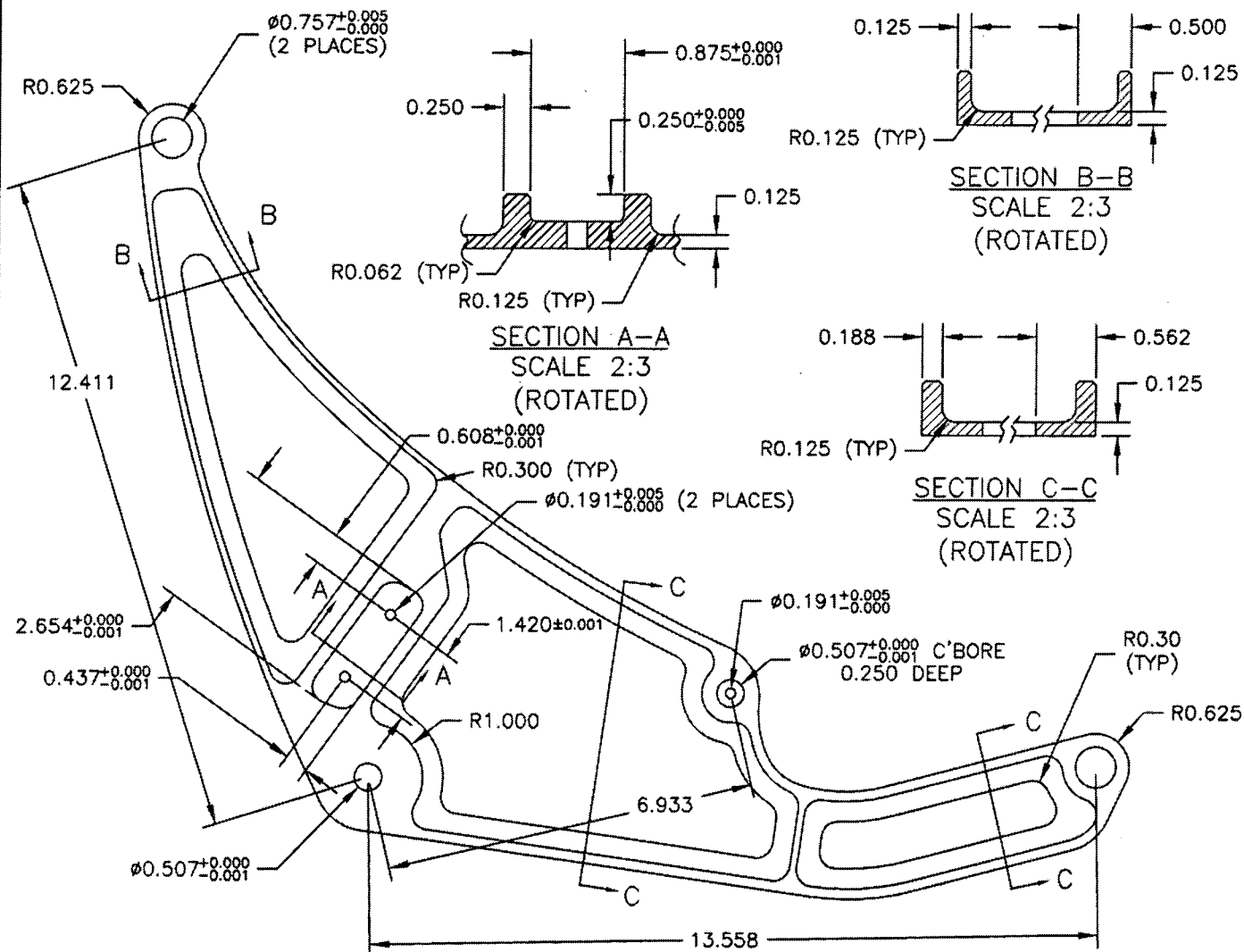


NO. *40724*
B/C - 8-31

RELEASED

05-03 11 *#*

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803
DATE	04.11.22	TITLE	STA 84 BRACKET	REV. B SHEET 1 OF 2
A	00.11.07	NEW ISSUE		SCALE 1:3
B	04.11.22	ADD CUTOUTS & -043/-044		



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

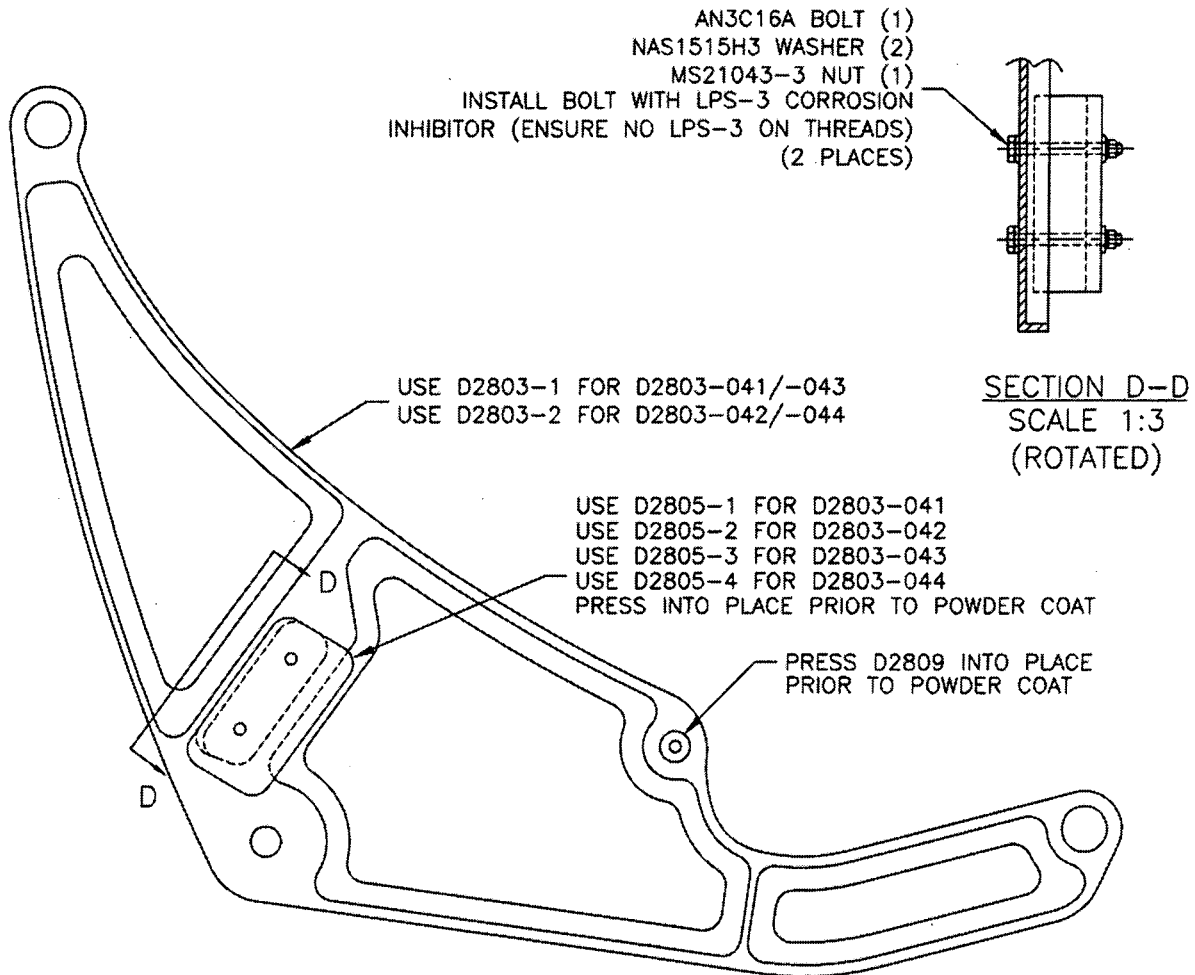
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3

**RELEASED**

05-03-11 [Signature]

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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